

Work Order ID 65359

January 12, 2011 2:57:54 PM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 1/12/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 11/01/13

Tooling:

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

S 11/01/13

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 13270

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 11/01/13

CL 11/01/13 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 65359

January 12, 2011 2:57:54 PM



Page 2

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Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

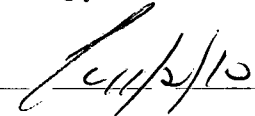

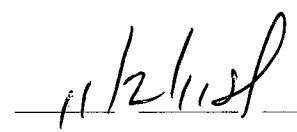
Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 120 Packaging | Receive & Inspect for Damage & Mat'l Certs Packaging | 0.00 | | | | | | | |
| Packaging | Memo Ensure a copy of Certification of Conformity and process sheet from Delastek is attached. | 0.00 | | | | | | |  ① |
| 130 QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo Check hole locations to template. DT 8824 Check process sheet and audit. | 0.00 | | | | | | |  |
| 140 Packaging | Pick Kit | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | |  |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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* NOTE: Date & initial all entries

Work Order ID 65359

January 12, 2011 2:57:54 PM

Page 3

Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 1/12/11 Start Qty: 1.00

Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: SGPPP Rev: G

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

1/14/14

1/02/14

1/11/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

January 12, 2011 2:57:53 PM

Page 1

Work Order ID: 65359

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 1/12/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--------|--|-----------|----|--|--|-----|------|---------|---|---|--|--|--|
| 2600-6 | | Purchased | No | | | 110 | Each | 85.0000 | 4 | 4 | | | |
|--------|--|-----------|----|--|--|-----|------|---------|---|---|--|--|--|



Camlock Stud

Location Loc Qty Loc Code

| | | |
|--------|----|--|
| ST381 | 85 | |
| 114238 | 4 | |
| 115814 | 17 | |
| 116373 | 14 | |
| 116513 | 50 | |

CL 11/01/18

| | | | | | | | | | | | | | |
|-------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2268 | | Manufactured | No | | | 140 | Each | 11.0000 | 1 | 1 | | | |
|-------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|



Decal

Location Loc Qty Loc Code

| | | |
|-------|----|--|
| ST010 | 11 | |
| 60213 | 1 | |
| 64072 | 10 | |

11/2/11sf

| | | | | | | | | | | | | | |
|-------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2269 | | Manufactured | No | | | 140 | Each | 19.0000 | 1 | 1 | | | |
|-------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|



Decal

Location Loc Qty Loc Code

| | | |
|-------|----|--|
| ST010 | 19 | |
| 63338 | 7 | |
| 64437 | 12 | |

11/2/11sf

| | | | | | | | | | | | | | |
|---------------|--|-----------|----|--|--|-----|------|--------|---|---|--|--|--|
| D350-604-041P | | Purchased | No | | | 120 | Each | 0.0000 | 1 | 1 | | | |
|---------------|--|-----------|----|--|--|-----|------|--------|---|---|--|--|--|



Rear Locker Extender

B65359 11/2/11sf

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4

REF FAA STC: SR00463NY

PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

| QTY | PART NUMBER | DESCRIPTION |
|------|--------------|---------------------------------------|
| -041 | | |
| X | D350-604-041 | REAR CARGO COMPARTMENT EXTENDER ASS'Y |

IS:

| | | |
|---|--------|-------------|
| 4 | 2600-6 | CAMLOC STUD |
|---|--------|-------------|

WAS:

| | | |
|---|--------|-------------|
| 4 | 2600-4 | CAMLOC STUD |
|---|--------|-------------|

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65359
CX 11/01/13

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

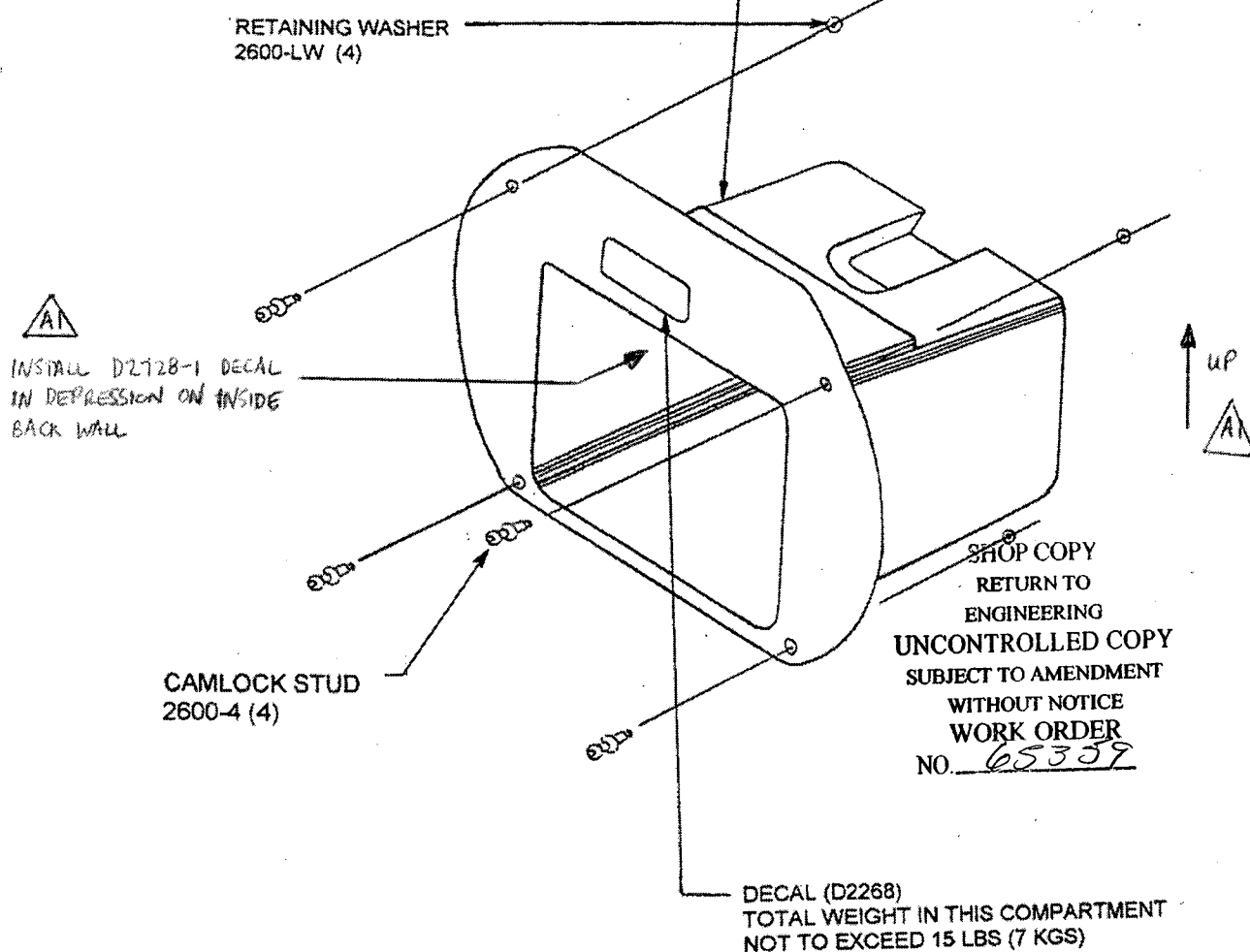
DATE: 09.07.01
CERT. NO.: SH90-4
ISSUE NO.: 3

| | | | |
|------------|-----------------------|--|--------------|
| A | NEW ISSUE, NCR 09-046 | CP | 09.07.01 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <u>92</u> | DART AEROSPACE LTD | |
| DRAWN | <u>97</u> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <u>[Signature]</u> | DRAWING NO. | REV. A |
| MFG. APPR. | <u>NIA</u> | DSI 9470 | SHEET 1 OF 1 |
| APPROVED | <u>[Signature]</u> | TITLE | SCALE |
| DE APPR. | <u>[Signature]</u> | CAMLOC CHANGE | NTS |
| DATE | 09.07.01 | COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |



| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN BW | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D350-604-041 | REV. A SHEET 1 OF 1 |
| DATE 02.04.01 | | TITLE REAR LOCKER EXTENDER ASSEMBLY | SCALE NTS |
| A | 02.04.01 | NEW ISSUE | |
| AI | 02.04.23 | ADD D2728-1 DECAL & ORIENTATION NOTE REAR LOCKER EXTENDER (D2273) | |

RELEASED
02.04.03



D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE AI

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13270

Purchase Order Date 1/13/11

PO Print Date 1/13/11

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 123

VU-DEL003

GRAND-MERE, QC G9T 5K7
CA

| | | | |
|--------------------|--------------|-----------------|---------------------|
| Contact Name | | Buyer | Chantal Lavoie |
| Vendor Phone | 819 533 5788 | Requisition Nbr | |
| Vendor Fax | 819 533 3494 | Tax Resale Nbr | 10127-2607 |
| Vendor Account Nbr | | Terms | Net 30 |
| | | Currency | USD |
| | | FOB | Destination-Collect |

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
2/11/11

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|------------------------|--|-----------------------------|------------------|------------|-------------------|
| 1 | D350-604-041P | Rear Locker Extender | 2/04/11 Yes | 1.00 Each | Purolator ground | \$330.0000 | \$330.00 |
| | | Special Inst: | AS PER DWG D350-604/D2273 REV. A/D B65357 ✓ | | | | |
| 2 | D350-604-041P | Rear Locker Extender | 2/04/11 Yes | 1.00 Each | Purolator ground | \$330.0000 | \$330.00 |
| | | Special Inst: | AS ABOVE B65358 ✓ | | | | |
| 3 | D350-604-041P | Rear Locker Extender | 2/04/11 Yes | 1.00 Each | Purolator ground | \$330.0000 | \$330.00 |
| | | Special Inst: | AS ABOVE B65359 ✓ | | | | |
| 4 | D350-604-041P | Rear Locker Extender | 2/04/11 Yes | 1.00 Each | Purolator ground | \$330.0000 | \$330.00 |

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 1/13/11



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

| | |
|------------|---------|
| Invoice # | 37081 |
| Customer # | DART US |

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200
Contact: Linda Lacelle

| Ship via | | F.O.B. | | Terms | | Salesperson | |
|--------------|------------|---------------|----------------|--|-----------|--------------------------|--|
| Puro Collect | | Origin | | Net 30 days USA | | Claude Lessard, ext. 233 | |
| Ship date | Order Date | Our PO # | Order by | | Your PO # | GST/PST # | |
| 09/02/2011 | 13/01/2011 | 16463 | Chantal Lavoie | | PO13270 | | |
| Order Qty | B.O. Qty | Current Ship. | Item # | Item Description | | | |
| 1 | 0 | 1 | DKC134-0003 | Line #3 Rear Locker Extender D350-604-041P B65359 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <u>No. série</u> B65359 <u>No. lot</u> 30994 | | | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Lundi, 2011-01-10 15:54:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 30994
Numéro Soumission : 3482
Numéro B.A. :
Cette fois : 2011-01-10 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 30993

Nom Dessin : REAR LOCKER EXTENDER
Numéro Article : DKC134-0003
Numéro Dessin : D350-604-041 & D2273
Projet Numéro : DK-362
Révision dessin : A & D
Matériel : Derakane 470-36/411/510
Date Dûe : 2011-01-17 Qté: 1 Udm: UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Laminée Dart Aerospace: D2273
N° de pièce Assemblage Dart Aerospace: D350-604-041



B65359

Process Sheet Rév.: 01 Mise en page selon nouvelle forme.

Déplacer cette seq. 12 en avant de la seq. 6. Ajouter sablage dans
seq. Trimage.

Produit additionnel

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|----------------------|
| 1.0 | PRÉPARATION | Préparation du moule |
|-----|-------------|----------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: 31/01/11 Sceau:



| | | |
|-----|---------|-------------------------------|
| 2.0 | AMB0350 | Gel Coat Blanc N° Gel 944W005 |
|-----|---------|-------------------------------|

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-29548-1

| | | |
|-----|---------|-------------------|
| 3.0 | AMB0286 | Catalyst N° DDM-9 |
|-----|---------|-------------------|

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

| | | |
|-----|--------|---------|
| 4.0 | AC0747 | Acetone |
|-----|--------|---------|

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

| | | |
|-----|--------------|-------------------------|
| 5.0 | PREP-GENERAL | Préparation du matériel |
|-----|--------------|-------------------------|



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 17-01-11 Sceau: NT

Date: Lundi, 2011-01-10 15:54:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30994

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon IF134-0003 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% d'acétone.

Date: 3/10/11 Sceau:



7.0 GEL COAT Application du Gel Coat



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 3/10/11 Sceau:



8.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.680 LITRE(s)/Unit Total: 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

1-29297-1

9.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-27829-1

10.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.6 VERGE(s)/Unit Total: 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-28776-2

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total: 1.140 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot:

1-22302-1

12.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité:

19%

Température:

70°F

Heure:

—

Date: Lundi, 2011-01-10 15:54:50

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 30994

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date: 1/02/11

Sceau:



13.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot:

14.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

15.0 FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité:

Date:

Sceau:

16.0 DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1

Date: 1/02/11

Sceau:



17.0 TRIMAGE

Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1

Date: 3/02/11

Sceau:



18.0 AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-28961-2

Date: Lundi, 2011-01-10 15:54:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30994

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---|
| 19.0 | AAC1101 | N° 7775S, Dupont Activator - Reducer Chromabase |


Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-28961-3

| | | |
|------|--------|--------------------|
| 20.0 | PRIMER | Application primer |
|------|--------|--------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.

Quantité: 1 Date: 4-02-11 Sceau:  N° fiche de Mélange: N/A

| | | |
|------|---------|--|
| 21.0 | AAC1607 | Camlock Stud 2600-4 (or Monadnock 1126000-4) |
|------|---------|--|

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)
Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot: 1-28803-1

| | | |
|------|---------|--------------------------|
| 22.0 | AAC0682 | Washer 2600-LW (1127700) |
|------|---------|--------------------------|

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)
Washer 2600-LW (1127700) N° de Lot: 1-6687-1

| | | |
|------|------------|----------------------|
| 23.0 | ASSEMBLAGE | Assemblage mécanique |
|------|------------|----------------------|



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasker la pièce.

Assembler les "Studs" selon IG 0037.


Quantité: 1 Date: 7/02/11 Sceau: 

| | | |
|------|----------------|-----------------------------------|
| 24.0 | IDENTIFICATION | Identification à encre indélébile |
|------|----------------|-----------------------------------|



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005


Quantité: 1 Date: 7-02-11 Sceau: 

| | | |
|------|--------------|-------------------|
| 25.0 | INSPEC FINAL | Inspection finale |
|------|--------------|-------------------|



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 07-02-11 Sceau: 

Date: Lundi, 2011-01-10 15:54:50
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 30994

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

26.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1

Date:

07 fev 11

Sceau:

L.B

fab 7 fev 11

Job 30994

D 350-604-041